27

QC8- Inspect parts - second check

Memo

120

120

Quality Control

DQA:			Date:											DADT
						WORK ORDER NON	-CO	ONFO	RMANCE / UP	PDATE				AEROSPACE
QA Closed:			Date:								Vork Order	update only		
Work Ord	or.					DISPOSITION				AGAINST [EPARTME	NT/PROCESS		
Work Ord	er.					Rework	1	1	Skid-tube	Crosstube		Water Jet		Engineering
Part I	Vo					Scrap	1		Machining	Small Fab	۱ -	rod. Eng. Coor.	-	Quality
Full	•0.				-	Use-as-is	1		noforming	Finishing	_	tore/Packaging	-	Other
NCR I	Vo.					Suspected Unapproved	1	111.0111	Large Fab	Composite		Supplier	-	1
	79				_	A A A	_						_	
Root					Desc	ription of work order update		Initial	Acti	on	Sign &	507 201		
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descri	ption	Date	Verification	n	QC Inspector
Design														
Doc/Data	Ш								2.					
Equip/Tooling	_													
Handling/Pre	_													
Material	-													
Operator	-													
Offset/Setup	_													
Process	_													
Supplier	1													
Training														
Transport Unapproved														
Ollapproved							FA	ULT CAT	TEGORY					
Landi	ng (Gear			3.5	General								
58.000		Bending				Bend		Folio/P	rogram	Γ	Outside [imensions		Pressure/Forced
2.6		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Und	ler tolerance		Set-up
		Cracks				Broken/Damage/Defect		Hardwa	ire		Part Inco	rect		Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost,	Missing		Weld
		Cuffs				Contamination		Instruct	tions Incomplete/U	nclear	Part Mov	ed		Wrong Stock Pulled
		Crushing				Countersink		Misalig	gned/off center	[Positione	d Wrong		-
		Heat Trea	it			Cut Too Short		Mislabe	eled	[Power Lo	ss/Surge		Other
		Inspection	n Strip in	Tube		Drawing		Misread	d					
		Marks/Ch	atter			Drill Holes		Off-set			45			
		Turning S	equence			Finish		Out of (Calibration					
		Wave/Tw	ist in Tub	e		Fit/Function		Out of S	Sequence					

Work Order II	119663
Friday, May 16, 2014	1:58:49 PM

110663

Friday, May 16,	2014 1:58:49 PM	f			100.5°					Page 2
Revision ID:	D3537-1 Wearpad			Accept	*N900	04010	0 *	Setup S	tart *N	S1*
Start Date: Required Date: Reference:		art Qty: 50.00 q'd Qty: 50.00	*50* *50*		Cust Item 1 Customer:	D:			* *N	52"
Approvals:	Process Plan:QC:	1 2	Date:	Tooling: SPC (Y/N):		ate:	•		tart *N	R1*
Sequence ID/ Work Center ID		eration cription		Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty	Reject Qty		Insp. Stamp
130 Brake NC	NC I	Memo 1-Form as pe Identify as D	er Dwg D3537 on CNC bra 3537-1	0.00	nd DT 8326.2-	DAS 30 9-89	60	-::		146
140 *140* Large Fab	Larg	e Fab Memo		0.00			60			14-05-
Large Filb	M123895	MIL9283 Desc	ription Batch. 1-Weld as per Dwg D3537 netrated through Wearpadif	A/R 2059B Hard- using Jig DT 82102-Re	coat move any					<i>y</i>
*150 *150* QC Quality Control	QC1	0- Inspect visual per Memo	QSI004- ground welds	0.00			(6))	1.0530	DAS 9-89
							A.			

DQA:			Date:											DART
						WORK ORDER NON-	-CC	ONFO	RMANCE / UF	PDATE				AEROSPACE
QA Closed:			Date:								W	ork Order up	odate only	
Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS	
Tronk Grak					_	Rework	1		Skid-tube	Crosstube		1	Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming	Finishing		Rec/Stor	re/Packaging	Other
NCR N	10.				_	Suspected Unapproved			Large Fab	Composite			Supplier	
Root					Desci	ription of work order update		nitial	Acti	ion		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption		Date	Verification	QC Inspector
Design														
Doc/Data		s.												
Equip/Tooling														
Handling/Pre														
Material														
Operator														
Offset/Setup		Į.												
Process		c:		1										
Supplier														
Training														
Transport														
Unapproved														
							FAI	ULT CAT	TEGORY		_			
Landi	ng (Sear				General						1	-	-
		Bending				Bend		- Alexander	rogram			Outside Dim	_	Pressure/Forced
		Centre No	t Concer	ntric		BOM/Route		Grain			_	Over/Under	-	Set-up
		Cracks				Broken/Damage/Defect		Hardwa				Part Incorred		Temperature/Cure
		Crimp/Kin	k/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified		Part Lost/Mi		Weld
		Cuffs				Contamination		Contract Septiment	tions Incomplete/U	Inclear		Part Moved		Wrong Stock Pulled
		Crushing				Countersink			gned/off center			Positioned V		
		Heat Trea	t			Cut Too Short		Mislabe				Power Loss/	Surge	Other
		Inspection		Tube		Drawing		Misread	d					
		Marks/Ch	atter			Drill Holes		Off-set				//		
		Turning Se	equence			Finish		Out of (Calibration					
		Wave/Tw	ist in Tub	e		Fit/Function		Out of S	Sequence					

119663 Page 3 Friday, May 16, 2014 1:58:49 PM Item ID: D3537-1 Accept *N900040100* Setup Start Revision ID: Stop Item Name: Wearpad *50* Start Date: 5/15/14 **Start Qty: 50.00** Cust Item ID: Required Date: 5/15/14 Reg'd Oty: 50.00 *50* Customer: Reference: Start Run Process Plan: Approvals: Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool # Plan Tool ID Accept Reject Reject Insp. Work Center ID Description **Run Hours** Qty Code Qty Number Stamp DAS 160 QC5- Inspect part completeness to step on W/O 0.00 9 *160* 14-05-30 9-89 OC 0.00 Memo Quality Control 170 Grey Sandtex(Ref:4.3.5.6) per/QSI005 4.3 0.00 H & 14-5-30 BL *170* Powdercoat 0.00 Memo Powder Coating OVEN PEMPERATURE: FINISH TIME: DAS 0.0027 180 QC3- Inspect Part Finish *180* 0.00 Memo Quality Control

DQA:			Date:										DART
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:		11	Date:							W	ork Order up	date only	
Work Orde	r:					DISPOSITION			AGAINST	DE	PARTMENT/	PROCESS	
					_	Rework			Skid-tube Crosstube]	Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fab		Prod	d. Eng. Coor.	Quality
						Use-as-is		Thern	moforming Finishing		Rec/Stor	e/Packaging	Other
NCR N	lo.					Suspected Unapproved			Large Fab Composite			Supplier	
Root	П				Desci	ription of work order update	ı	nitial	Action		Sign &	NASC 100-000 18	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Operator													
Offset/Setup											1		
Process													
Supplier					-45								
Training													
Transport													
Unapproved													
							FAI	ULT CAT	TEGORY				
Landin	ng (Sear				General		1			ik sa ses		T
		Bending				Bend			Program	_	Outside Dim	_	Pressure/Forced
		Centre No	t Concer	ntric		BOM/Route		Grain		_	Over/Under		Set-up
		Cracks				Broken/Damage/Defect		Hardwa		_	Part Incorrec	_	Temperature/Cure
		Crimp/Kir	k/Ripple	/Wave		Burrs		-	ion Incomplete/Unqualified	_	Part Lost/Mi	ssing	Weld
		Cuffs				Contamination		4	tions Incomplete/Unclear		Part Moved	L	Wrong Stock Pulled
		Crushing				Countersink			gned/off center	_	Positioned W		7
		Heat Trea	t			Cut Too Short		Mislabe			Power Loss/	Surge	Other
		Inspection	n Strip in	Tube		Drawing		Misrea					
		Marks/Ch	atter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of	Calibration				
		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence				

*									
Work Ord Friday, May 16				*119	9663*		Shi.	nvak- a	Page
Item ID: Revision ID:	D3537-1		9	Accept	*N900	040100	7*	Setup Start	*NS1*
Item Name:	Wearpad							Stop	*NS2*
Start Date:	5/15/14	Start Qty: 50.00	*50*		Cust Item 1	ID:			1.2.
Required Date	: 5/15/14	Req'd Qty: 50.00	*50*		Customer:				
Reference:			. 107						
Approvals:	Process P	lan:	Date:	Tooling:	D	ate:		Run Start	*NR1*
	QC:		Date:	SPC (Y/N):	D	ate:		Stop	*NR2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty		Reject Insp. Number Stamp
190		Identify as per dwg & Stock	k Location: 100	0.00			1	110	2
100 Packaging		Memo		0.00			u	14.05.	D
Packaging		WE STORY							

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

200

Quality Control

W14.05.30

47

DQA:			Date:										DART
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	er.					DISPOSITION			AGA	INST DE	PARTMENT/	PROCESS	
VVOIK OIGE	-				-	Rework	1		Skid-tube Cross	tube	1	Water Jet	Engineering
Part N	lo.					Scrap			Machining Small		Proc	d. Eng. Coor.	Quality
1,20,51.					_	Use-as-is				shing	Rec/Stor	e/Packaging	Other
NCR N	lo.					Suspected Unapproved			Large Fab Compo	osite]	Supplier	
						S 50 1						**	
Root					Desci	ription of work order update	- 1	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data	_												
Equip/Tooling	_												
Handling/Pre	4												
Material	_												
Operator	_												
Offset/Setup	\dashv												
Process	\dashv												
Supplier	\dashv												
Training	-												
Transport Unapproved	_												
Опарргочец							FAI	ULT CA	TEGORY				•
Landi	ng G	Gear				General					-10.1		
		Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
		Centre No	t Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	ct	Temperature/Cure
		Crimp/Kin	k/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified	d	Part Lost/Mi	ssing	Weld
		Cuffs				Contamination		Instruc	tions Incomplete/Unclear		Part Moved	L	Wrong Stock Pulled
		Crushing				Countersink		-	gned/off center		Positioned V		7
		Heat Trea	it			Cut Too Short		Mislab			Power Loss/	Surge	Other
		Inspection	n Strip in	Tube		Drawing		Misrea			-		
		Marks/Ch				Drill Holes		Off-set					
		Turning S				Finish		-	Calibration				
		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence				

Page 1

Work Order ID: 119663

119663

Parent Item:

D3537-1

D3537-1

Parent Item Name: Wearpad

Start Date: 5/15/14

Required Date: 5/15/14

Start Qty: 50.00

Required Qty: 50.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304816GA		Purchased	No			100	sf	300,7670	0.106	6			- 1 - 6
*M304516	C / *	Furchased	NO			100	st	300.7670	0.106	6		7.	111-

304/315 Sheet .D63

Location	Loc Qty	Loc Code	
MAT020	300.767		
M127821	75.567		
M128423	1.2		
M129192	224		129192

DQA:			Date:										DAPT
						WORK ORDER NON	I-CO	ONFO	RMANCE / UPDATE			-	AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
						DISPOSITION			AGAINST	DE	PARTMENT/	PROCESS	
Work Orde	er: _				_	Rework	٦		Skid-tube Crosstube		1	Water Jet	Engineering
Part N	lo.					Scrap	-		Machining Small Fab	-	Proc	d. Eng. Coor.	Quality
Faitiv	-					Use-as-is	1		noforming Finishing	-	V. 1011	e/Packaging	Other
NCR N	lo.					Suspected Unapproved	1		Large Fab Composite	-		Supplier	1
	_				_		_			_	1		
Root	T				Desc	ription of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design		4											
Doc/Data													
Equip/Tooling	_												
Handling/Pre	_												
Material	_												
Operator	_												
Offset/Setup	_												
Process	\dashv												
Supplier	\dashv												
Training	\dashv												
Transport	\dashv												
Unapproved							FΔ	IIIT CA	TEGORY				
Landir	ng G	ear				General	17	OLI CA	1200M				
Carron		Bending				Bend		Folio/F	Program		Outside Dime	ensions	Pressure/Forced
	-	Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under t	tolerance	Set-up
	-	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorrec	i -	Temperature/Cure
1	$\overline{}$	Crimp/Kir	nk/Ripple	/Wave		Burrs		-	ion Incomplete/Unqualified		Part Lost/Mis	ssing	Weld
	$\overline{}$	Cuffs	PESS	ANGUSUS CHURCO		Contamination		-	tions Incomplete/Unclear		Part Moved	(22)	Wrong Stock Pulled
	-	Crushing				Countersink		Misali	gned/off center		Positioned W	/rong	
	$\overline{}$	Heat Trea	it			Cut Too Short		Mislab	eled		Power Loss/S	Surge	Other
		Inspection	n Strip in	Tube		Drawing		Misrea	d	***	/		
		Marks/Ch	natter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of	Calibration		n-		
		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence				

DART AEROSPACE LTD	Work Order:	119663
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.250	+/-0.010	4.250	-		U	Itmos
3.500	+/-0.010	3.504	-		U	
1.965	+/-0.010	1.972"	-		U	17 115 114
2.795	+/-0.010	1.972	-		V	
3.625	+/-0.010	3.625	-		v	
0.220 x 0.380	+/-0.010	0.173 x0382	_		~	
					8	- 3
				F4 LEE		

Measured by:	JM	Audited by:	DAS 27	Prototype Approval:	N/A
Date:	14-05-24	Date:	1,169	Date:	N/A

Rev	Date Change		Revised by	Approved
Α	07.03.21	New Issue	KJ/JLM	
В	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	1
С	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM X	Gul!

SHOP COPY RETURN TO ENGINEERING

